Work Order ID 56186

February 12, 2010 9:52:31 AM

Item ID: D2803-1 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Bracket

Start Date: 12/02/2010 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 25/02/2010 **Req'd Qty:** 2.00 **Customer:**

Reference: 10.02.03.

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D2803	Rev B

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00 BLANKS				AR 10-2-12			
FLOW CNC Waterjet	1-Cut as per template DT8533 ☐Dwg Rev:_____☐Prog Rev:_____ ☐2-Deburr if necessary					(2)			
110	HAAS CNC VERTICAL MACHINING #1	0.00							
HAAS 1	**Memo**	0.00 10.2.16							
HAAS CNC vertical machine #1	Machine as per folio FA102								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00 10.2.16				(2)			
Quality Control									

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Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00	S.B 10/02/16			2	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 **Memo**	0.00 0.00	BK 10.02.17			(2)	0		
150 QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00	AL 10/02/17			(2)	0		

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Required Date: 25/02/2010 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: 147	0.00				2			
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

11/4/18

10/02/18 AJ

MF
10-2-18

Picklist Print

February 12, 2010 9:52:30 AM

Work Order ID: 56186

Parent Item: D2803-1

Parent Item Name: Bracket

Start Date: 12/02/2010 **Required Date:** 25/02/2010

Comments: IPP A□00.11.06□New Issue□EC□
IPP Rev:B Blanks Now Cut on Waterjet 06-06-14 JLM
IPP Rev:C Removed Tumbling 08-09-10 JLM Verified By:EC

Start Qty: 2.00 **Required Qty:** 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
M6061T6B0.500X10.00 0		Purchased	No			100	f	47.3000	4.0352			

6061-T6 Bar .500 x 10.00

EB 10-2-16

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
MAT	47.3		
109288	0.3		
111382	23		
112764	24		112764

DART AEROSPACE LTD	Work Order:	
Description: Bracket	Part Number:	D2803-1
Inspection Dwg: D2803 **Rev:** B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

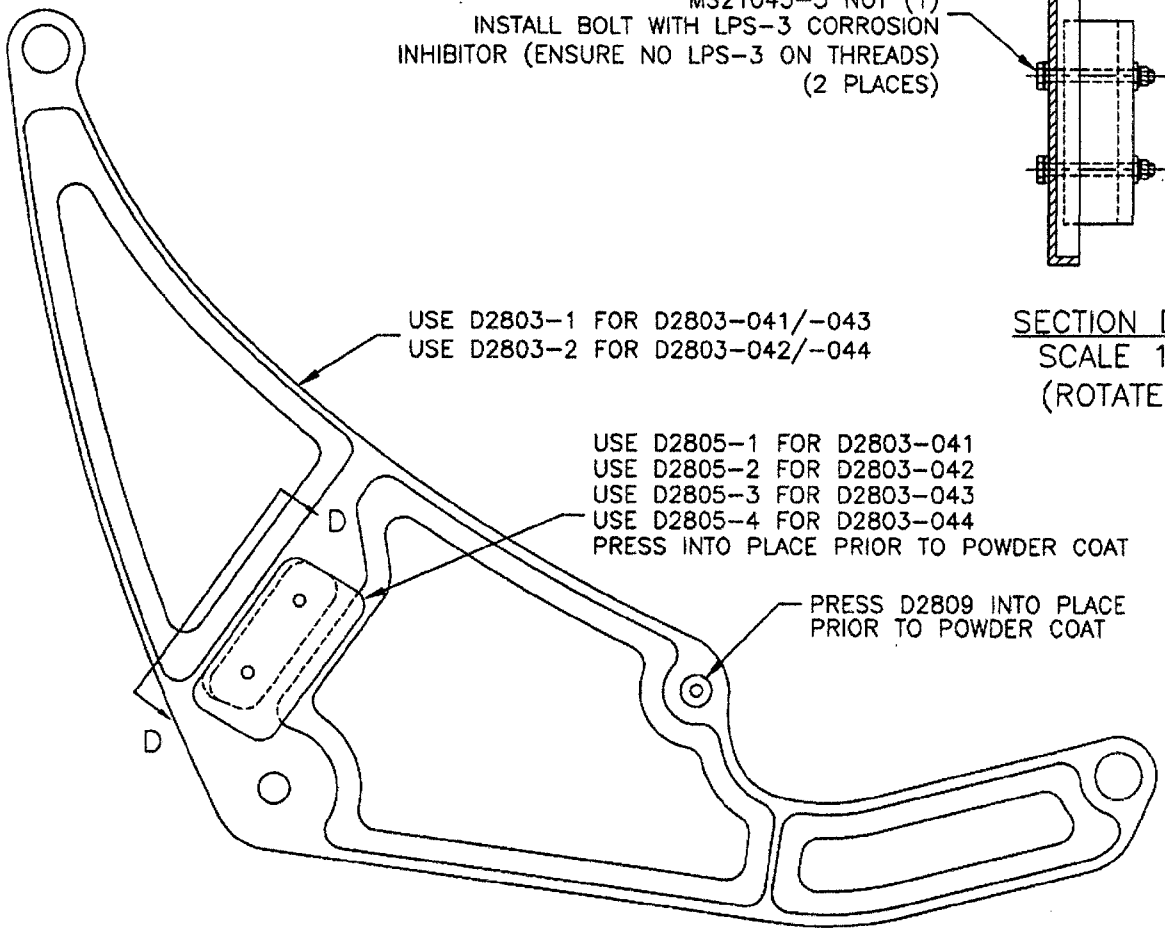
[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	.760	✓			
Ø0.191	+0.005/-0.000	.196	✓			
Ø0.507	+0.000/-0.001	.5065	✓			
13.558	+/-0.010	13.558	✓			
Ø0.507	+0.000/-0.001	.5065	✓			
12.411	+/-0.010	12.411	✓			
2.654	+0.000/-0.001	2.654	✓			
0.437	+0.000/-0.001	.4365	✓			
1.420	+/-0.001	1.420	✓			
6.933	+/-0.010	6.933	✓			
0.250	+/-0.010	.250	✓			
0.875	+0.000/-0.001	.8745	✓			
0.250	+0.000/-0.005	.247	✓			
0.125	+/-0.010	.125	✓			
0.125	+/-0.010	.125	✓			
0.125	+/-0.010	.125	✓			
0.125	+/-0.010	.125	✓			
0.500	+/-0.010	.500	✓			
0.562	+/-0.010	.562	✓			
0.188	+/-0.010	.188	✓			

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	10-2-16	Date:	10/02/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	07.07.18	12.625 dimension removed	KJ/JLM	

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CP	CP		
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2803	SHEET 2 OF 2
DATE		TITLE	SCALE
04.11.22		STA 84 BRACKET	1:3



5218

RELEASED
05-03-11

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

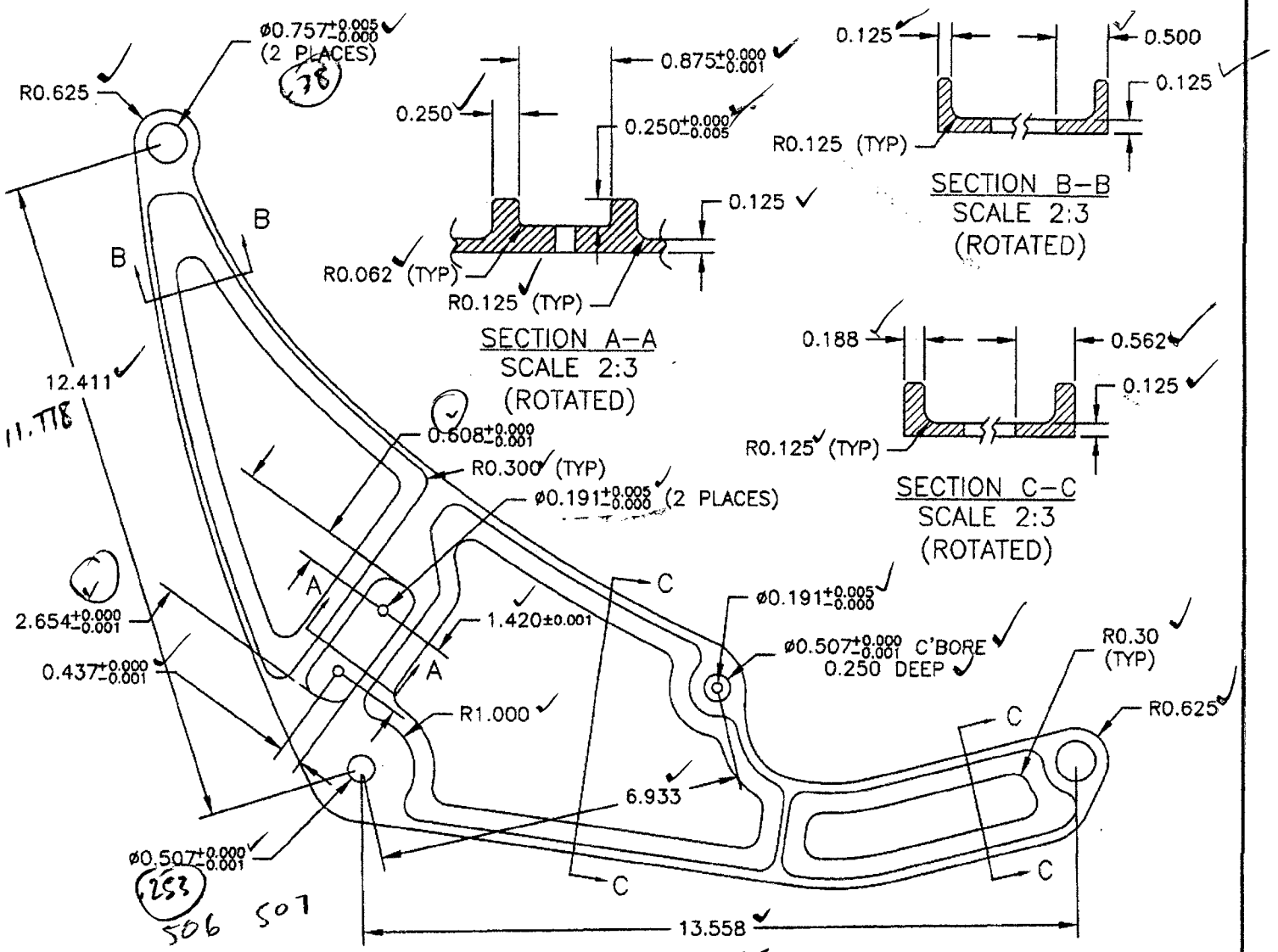
6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CP	CP		
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2803	SHEET 1 OF 2
DATE		TITLE	SCALE
04.11.22		STA 84 BRACKET	1:3

A	00.11.07	NEW ISSUE
B	04.11.22	ADD CUTOUTS & -043/-044

RELEASED
05.03.11



D2803-1 BRACKET (SHOWN), D2803-2 BRACKET (OPPOSITE)

1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
3) DEBURR TO LEAVE R0.030 – 0.063 ON ALL EDGES
4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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